

Date: Monday, 2/19/2007 3:27:09 PM  
 User: Kim Johnston

## Process Sheet

|   |                                      |
|---|--------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services      | Drawing Name : TAIL LIGHT FAIRING    |
| Job Number : 30774                                  |                                      |
| Estimate Number : 12362                             |                                      |
| P.O. Number :                                       | Part Number : D34845                 |
| This Issue : 2/19/2007 S.O. No. :                   | Drawing Number : D3484 REV D         |
| Prsht Rev. : NC                                     | Project Number : N/A                 |
| First Issue : 1 / Type : SMALL / MED FAB            | Drawing Revision : D                 |
| Previous Run : 27225                                | Material :                           |
|   | Due Date : 3/10/2007 Qty: 5 Um: Each |
| Written By : <u>                    </u>            |                                      |
| Checked & Approved By : <u>                    </u> |                                      |
| Comment : Est Rev:A New Issue 06-04-11 JLM          |                                      |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |             |                    |
|-----|-------------|--------------------|
| 1.0 | M6061T6S050 | 6061-T6 .050 Sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.2904 sf(s)/Unit Total : 1.4522 sf(s)  
 6061-T6 .050 Sheet  
 (M6061T6S050)  
 Batch: M17347

SAD 07/02/24 (5)

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET  
 Cut as per Dwg D3484

SAD 07/02/24 (5)

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/02/24 (5)

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

J-F 07/02/24 (5)

|     |             |                               |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr SAD 07/02/25 (5)

2-Roll as per Dwg D3484

ml 07/03/12

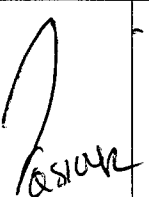
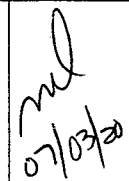

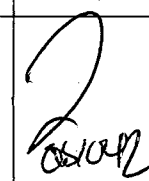

x3

PTO

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR)  |  |                                 |  |   |  |   |
|----------|------|---|--|---------------------------------|--|---|--|---|
| DATE     | STEP | Description of NC<br>Section A  | Corrective Action Section B  |                                 |  | Verification<br>Section C   | Approval<br>Chief Eng  | Approval<br>QC Inspector  |
|          |      |   | Initial<br>Chief Eng   | Action Description<br>Chief Eng | Sign &<br>Date   |   |  |   |
| 07/03/12 | 5    | Bend To much Two<br>part D 3484-5. Did not<br>able to do <del>perfecting</del> nice<br>job. (over bent) |  | destroy                         | <br>07/03/20 | <br>07/03/20 | <br>05/04/12 | <br>07/03/20 |
|          |      |   |  |                                 |  |   |  |   |
|          |      |   |  |                                 |  |   |  |   |

NOTE: Date & initial all entries

Date: Monday, 2/19/2007 3:27:09 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 30774

Part Number: D34845

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/20

3

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/04/10

3

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/11

Job Completion



07/04/11

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

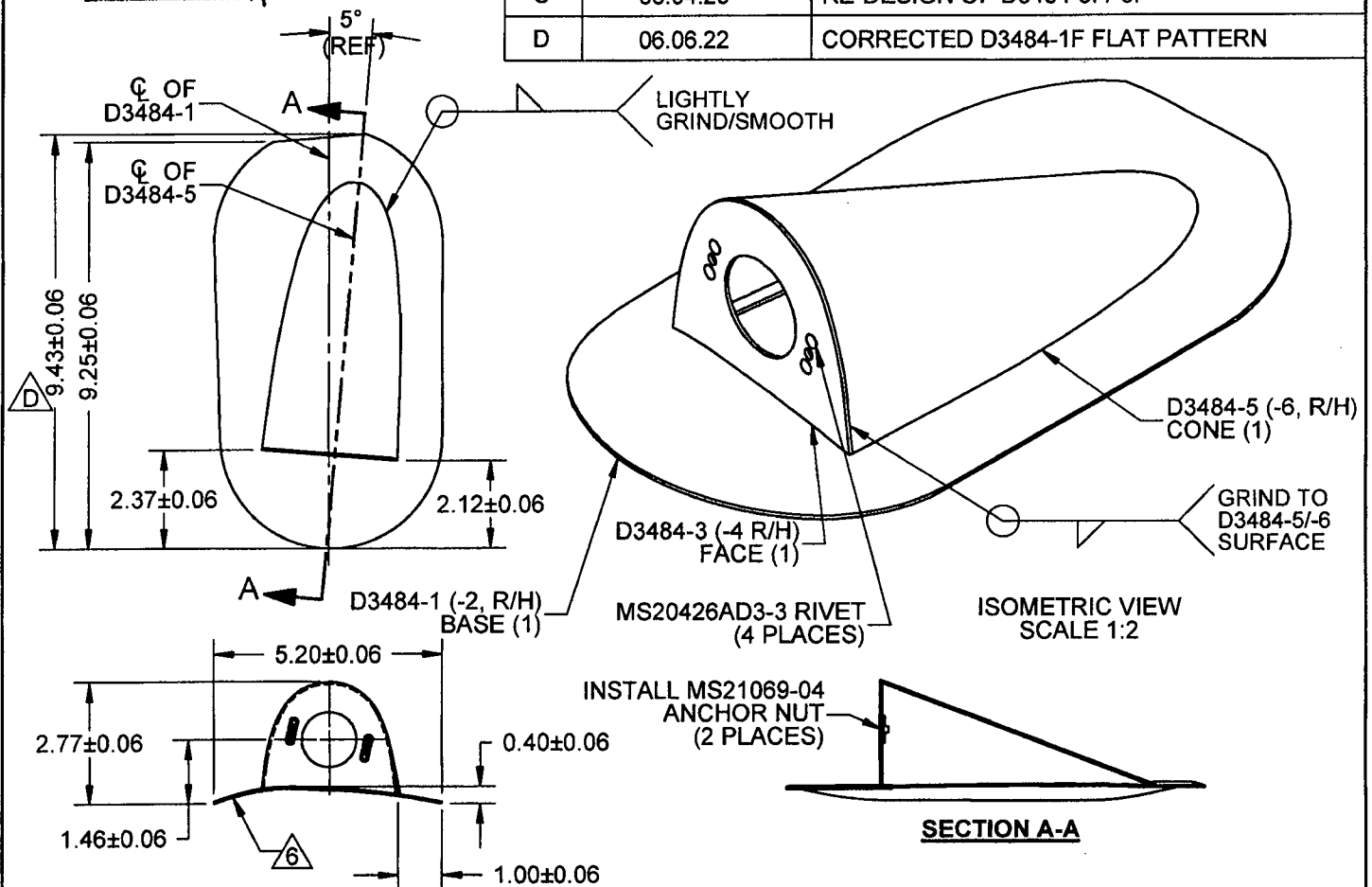
**NOTE:** Date & initial all entries

**DART**

|                         |               |  |                        |
|-------------------------|---------------|--|------------------------|
| DESIGN<br>B             | DRAWN BY<br>B | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>H            | APPROVED<br>H | DRAWING NO.<br><b>D3484</b>                              | REV. D<br>SHEET 1 OF 4 |
| DATE<br><b>06.06.22</b> |               | TITLE<br><b>TAIL LIGHT FAIRING</b>                       | SCALE<br>1:4           |
| A                       | 05.11.29      | NEW ISSUE  |                        |
| B                       | 06.02.21      | RE-DESIGN  |                        |
| C                       | 06.04.20      | RE-DESIGN OF D3484-3F/-5F                                |                        |
| D                       | 06.06.22      | CORRECTED D3484-1F FLAT PATTERN                          |                        |

**RELEASED**

06.08.17 H

**D3484-041 TAIL LIGHT FAIRING, L/H (SHOWN), R/H (OPPOSITE)****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:  
"TCCA-PDA, DART AEROSPACE LTD.,  
P/N D412-750-141/-142 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE  
PDA06-13"

| QTY<br>-041 | QTY<br>-042 | P/N          | DESCRIPTION                       |
|-------------|-------------|--------------|-----------------------------------|
| X           |             | D3484-041    | TAIL LIGHT FAIRING ASSEMBLY (L/H) |
|             | X           | D3484-042    | TAIL LIGHT FAIRING ASSEMBLY (R/H) |
| 1           |             | D3484-1      | BASE (L/H)                        |
|             | 1           | D3484-2      | BASE (R/H)                        |
| 1           |             | D3484-3      | FACE (L/H)                        |
|             | 1           | D3484-4      | FACE (R/H)                        |
| 1           |             | D3484-5      | CONE (L/H)                        |
|             | 1           | D3484-6      | CONE (R/H)                        |
| 4           | 4           | MS20426AD3-3 | RIVET                             |
| 2           | 2           | MS21069-04   | ANCHOR NUT                        |

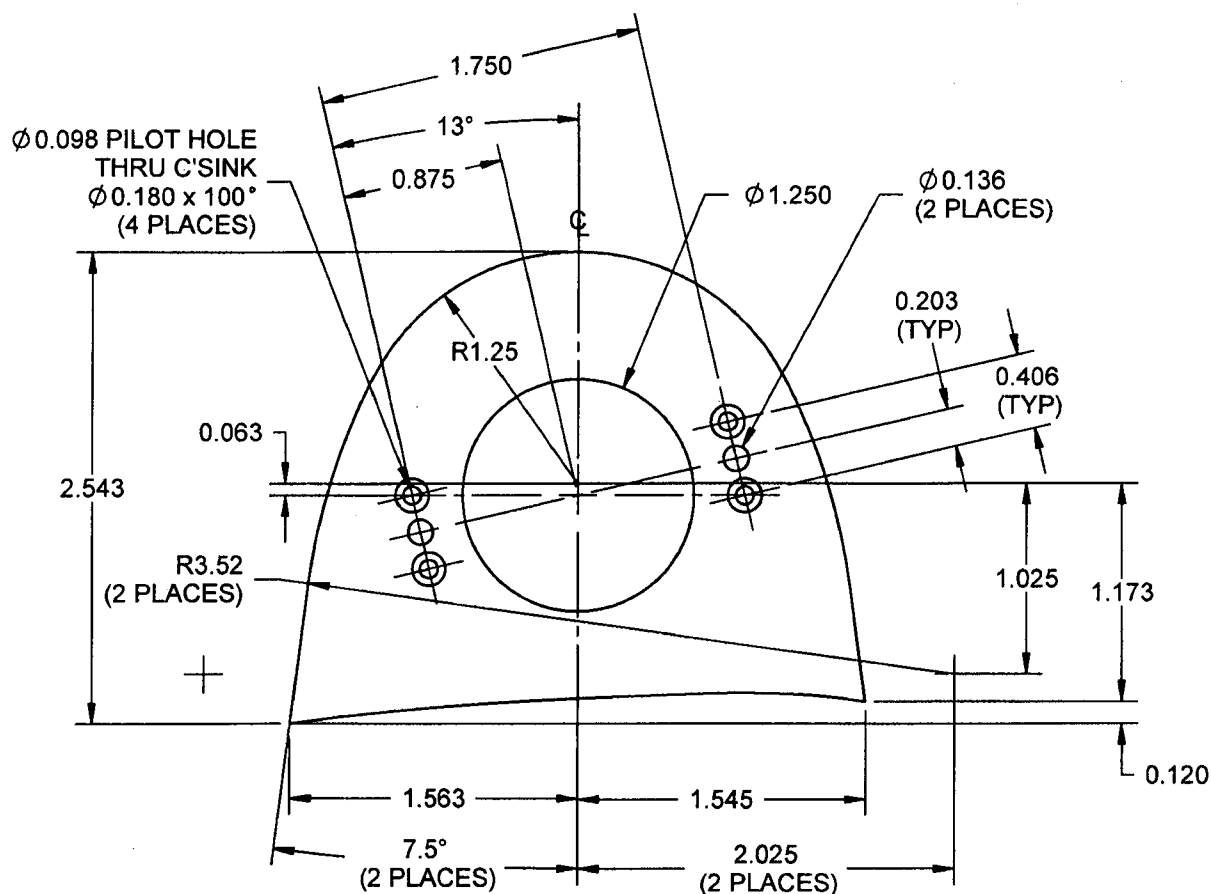
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|                  |                             |   |                        |
|------------------|-----------------------------|---|------------------------|
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| CHECKED<br>#     | APPROVED<br>#               | DRAWING NO.<br>D3484                              | REV. D<br>SHEET 3 OF 4 |
| DATE<br>06.06.22 | TITLE<br>TAIL LIGHT FAIRING |   | SCALE<br>1:1           |

**RELEASED**

06.08.17 #

**D3484-3 L/H FACE (-4 R/H, OPPOSITE)****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

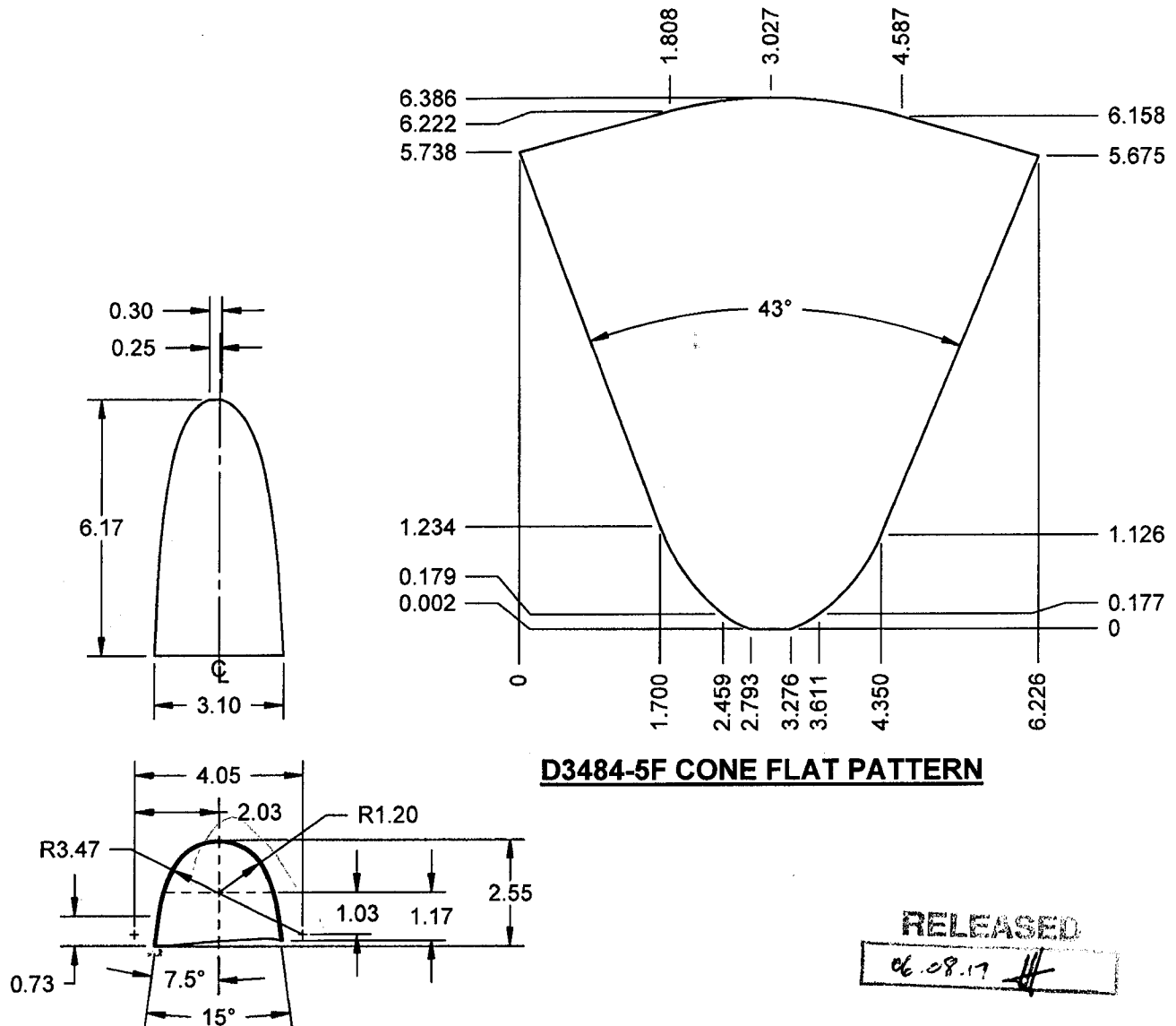
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|                         |               |  |                        |
|-------------------------|---------------|--|------------------------|
| DESIGN<br>B             | DRAWN BY<br>B | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>H            | APPROVED<br>H | DRAWING NO.<br><b>D3484</b>                              | REV. D<br>SHEET 4 OF 4 |
| DATE<br><b>06.06.22</b> |               | TITLE<br><b>TAIL LIGHT FAIRING</b>                       | SCALE<br>1:4           |

**D3484-5F CONE FLAT PATTERN****RELEASED**

06.08.17 H

**D3484-5 L/H CONE BENDING DETAIL (-6 R/H, OPPOSITE)  
(MAKE FROM D3484-5F)****NOTES:**

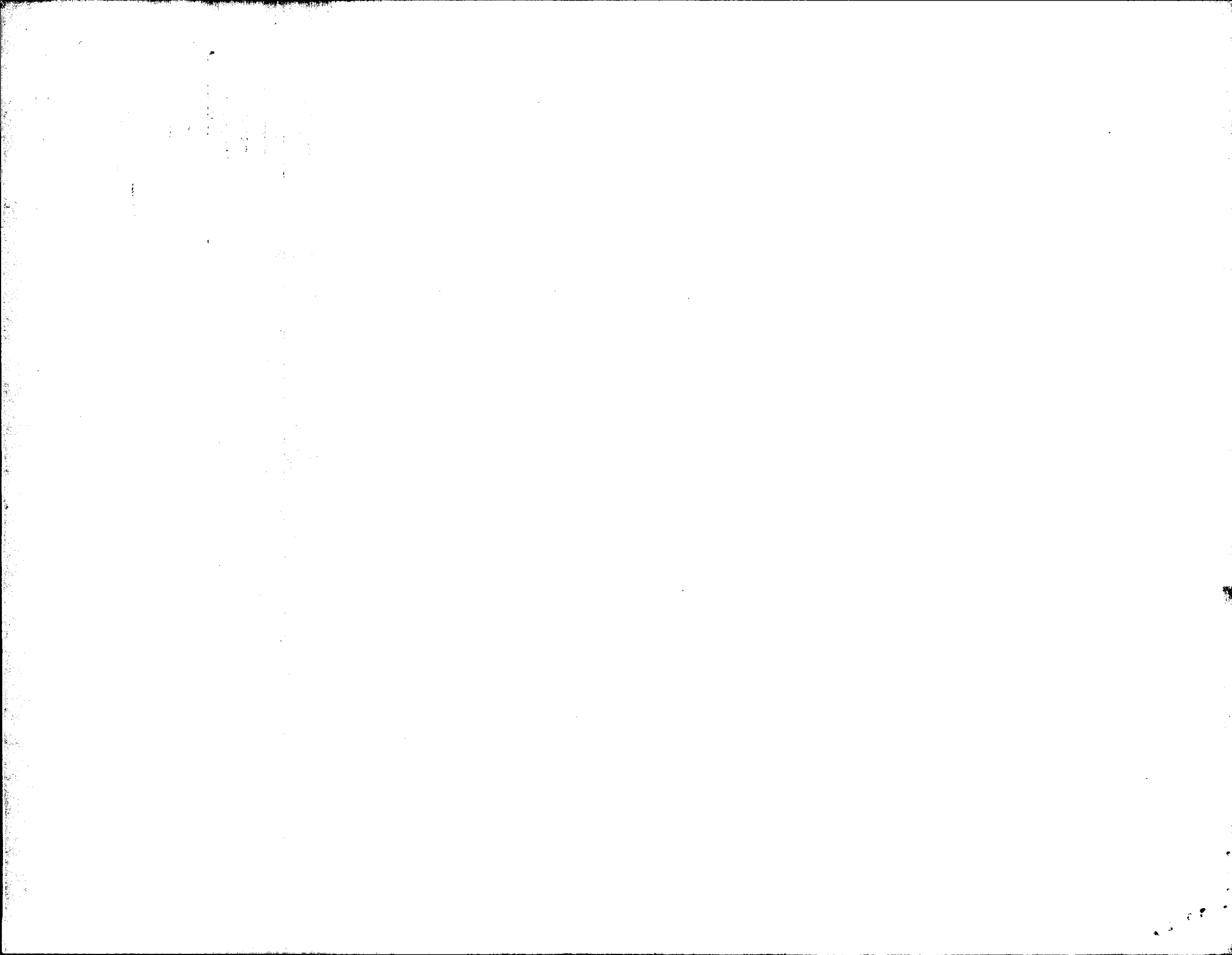
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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|                                 |  |              |                |
|---------------------------------|--|--------------|----------------|
| DART AEROSPACE LTD              |  | Work Order:  | 30774          |
| Description: <i>Cone LH</i>     |  | Part Number: | <i>D3484-3</i> |
| Inspection Dwg: , Rev: <i>D</i> |  | Page 1 of 1  |                |

# FIRST ARTICLE INSPECTION CHECKLIST

|                                     |               |                                     |           |
|-------------------------------------|---------------|-------------------------------------|-----------|
| <input checked="" type="checkbox"/> | First Article | <input checked="" type="checkbox"/> | Prototype |
|-------------------------------------|---------------|-------------------------------------|-----------|

[illegible]

|              |          |             |          |                     |     |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | SAD      | Audited by: | J.F.     | Prototype Approval: | N/A |
| Date:        | 07/02/24 | Date:       | 07/02/24 | Date:               |     |

|     |      |           |            |          |
|-----|------|-----------|------------|----------|
| Rev | Date | Change    | Revised by | Approved |
| A   |      | New Issue | KJ/JLM     |          |